



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.0210

Job Sheet 204984



Part No: 647.0210

Job Qty: 16 pcs

Part Name: Rail



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/23/19

Job Tracking No:

Due Date: 2/14/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	16 pcs	2/14/20		0.00	0.12	Bandsaw - 1	52 DAS 9-89	29/02/07
110	HAAS 4 Axis - B4B	16 pcs	2/14/20		0.67	16.16	HAAS - 1 - B4B	52 DAS 9-89	29/02/07
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	16 pcs	2/14/20		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51	DAS 52 9-89	29/02/07
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S254071



Part: 647.0210

Job No: 204984

Serial No/Batch: S254071

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/07/20

130	QC 8	16 pcs	2/14/20	0.00	0.00	QC 2 - 8								
						QC 2 - 66								
						QC 2 - 64								
						QC 2 - 65								
						QC 2 - 5								
						QC 2 - 71								
						QC 2 - 73								
						QC 2 - 69								
						QC 8 - 12								
						QC 8 - 14								
						QC 8 - 17								
						QC 8 - 20								
						QC 8 - 25								
						QC 8 - 3								
						QC 8 - 32								
						QC 8 - 33								
						QC 8 - 35								
						QC 8 - 39								
						QC 8 - 4								
						QC 8 - 44								
						QC 8 - 45								
						QC 8 - 49	mmmt 20/02/10							
						QC 8 - 58								
						QC 8 - 8								
						QC 8 - 9								
						QC 8 - 68								
						QC 8 - 67								
QC 8 - 1 (A)														
QC 8 - 47														
QC 8 - 40														
QC 8 - 52														
QC 8 - 23														
QC 8 - 57														
QC 8 - 76														
QC 8 - 61														
140	Outsource - 4 - Anodize	16 pcs	2/14/20			ATG001-VC	15	2020-02-10						
150	Packaging 2-1 - Receive - B4B	16 pcs	2/14/20	0.00	0.00	Packaging 2 - 1 - B4B								
						Packaging 2 - 2 - B4B								
						Packaging 2 - 3 - B4B								
						Packaging 2 - 5 - B4B								
						Packaging 2 - 4 - B4B								
						Packaging 2 - 6 - B4B								
						Packaging 2 - 7 - B4B								
						Packaging 2 - 8 - B4B								
						Packaging 2 - 9 - B4B								
						Packaging 2 - 10 - B4B								
						Packaging 2 - 11 - B4B								
						Packaging 2 - 12 - B4B								
						Packaging 2 - 13 - B4B								
						Packaging 2 - 14 - B4B								
						Packaging 2 - 15 - B4B								
						Packaging 2 - 16 - B4B								
														Plex 12/23/19 2:28 PM Dart.lajeunesse.marie

				Packaging 2 - 17 - B4B				
				Packaging 2 - 18 - B4B				
				Packaging 2 - 19 - B4B				
				Packaging 2 - 20 - B4B				
				Packaging 2 - 21 - B4B				
				Packaging 2 - 22 - B4B				
				Packaging 2 - 23 - B4B				
				Packaging 2 - 24 - B4B				
				Packaging 2 - 25 - B4B				
				Packaging 2 - 26 - B4B				
				Packaging 2 - 27 - B4B				
				Packaging 2 - 28 - B4B				
				Packaging 2 - 29 - B4B				
				Packaging 2 - 30 - B4B				
				Packaging 2 - 31 - B4B				
				Packaging 2 - 32 - B4B				
				Packaging 2 - 33 - B4B				
				Packaging 2 - 34 - B4B				
				Packaging 2 - 35 - B4B				
				Packaging 2 - 36 - B4B				
				Packaging 2 - 37 - B4B				
155	QC 6	16 pcs	2/14/20	0.00	0.00	QC 6 - 9	DAS	DAS
						QC 6 - 68	40	82
						QC 6 - 61	9-89	9-89
						QC 6 - 40	FEB 25 2020	
						QC 6 - 81		
180	Packaging 3-1 - Stock - B4B	16 pcs	2/14/20	0.00	0.00	Packaging 3 - 1 - B4B		
						Packaging 3 - 2 - B4B		
						Packaging 3 - 3 - B4B		
						Packaging 3 - 4 - B4B		
						Packaging 3 - 5 - B4B	DAS	
						Packaging 3 - 6 - B4B	28	
						Packaging 3 - 7 - B4B	9-89	
						Packaging 3 - 8 - B4B		
						Packaging 3 - 9 - B4B		
						Packaging 3 - 10 - B4B		
						Packaging 3 - 11 - B4B		
						Packaging 3 - 12 - B4B		
						Packaging 3 - 13 - B4B		
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				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
190 QC 21 - SA	16	2/14/20	0.00 0.00	QC 21 - SA - 21	DAS
	pcs			QC 21 - SA - 70	21 FEB 25 2020
				QC 21 - SA - 53	9-85

Part Op **100** - (Bandsaw) Cut Blank at 15.800"

Descriptions: **110** - (HAAS CNC Vertical Machine) 1-Machine per folio FB138

120 - (QC2- Inspect parts off machine FAI/FAIB)

130 - (QC8- Inspect parts - second check)

140 - (Outsource process-Anodize per QSI017 4.1.10.1) Issue P/O to ATG : 45819 AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.2, PRIME AS PER IAW MIL-PRF-23377 TYPE 1 CLASS N

150 - (Receive & Inspect for Damage & Mat'l Certs)

155 - (QC6- All purchased or subcontracted products)

180 - (Identify as per dwg & Stock Location: _____) ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T6S1.750X2.250	7075-T6 Sheet 1.750" X 2.250"	21.1200 ft (1.32 ea)	100-Bandsaw - 1	5136957

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M7075T6S1.750X2.250	21	109	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Rail	0.201Inches + 0.005 - 0.001	0.206 0.200	Diameter	0.201
2	Rail	0.229Inches ± 0.005	0.234 0.224		0.229
3	Rail	0.190Inches ± 0.010	0.200 0.180		0.193
4	Rail	1.100Inches ± 0.010	1.110 1.090		1.096
5	Rail	0.830Inches ± 0.005	0.835 0.825		0.830
6	Rail	2.000Inches ± 0.010	2.010 1.990		2.000
7	Rail	0.340Inches + 0.000 - 0.005	0.340 0.335		0.339
8	Rail	0.125Inches ± 0.005	0.130 0.120	Radius	0.125
9	Rail	0.063Inches ± 0.005	0.068 0.058	Radius	0.063

DAS

52

9-89

20/02/07

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Eng. (Non-AW) ☐ Machining ☐ Prod. Eng. Coord. ☐ Large Fab ☐ Rec/Store/Packaging ☐ Cross tube ☐ Small Fab ☐ Finishing ☐				Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	
Date :	Sequence #:	QTY Affected :		MRB (QS1042)					
Description Work Order Deviation				Disposition					
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				FAULT CATEGORY Contamination ☐ Power Loss/Surge ☐ Positioned Wrong ☐ Misaligned/off center ☐ Folio/Program ☐ Outside Tolerance ☐ BOM/Route ☐ Grain Direction ☐ Drawing ☐ Broken/Damage/Defect ☐ Weld ☐ Finish ☐ Incomplete/Unclear Instructions ☐ Wrong Stock Pulled ☐ Part Lost/Missing ☐ Drill Holes ☐ Out of Sequence ☐ Misread ☐ Fit/Function ☐ Off-set/Set-up ☐					
				Pressure/Forced ☐ Other/Details: _____ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐					
				Completed By _____ Lead hand / Supervisor _____ QC / QA Coordinator _____					



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PURCHASE ORDER

POHB045819



Supplier: ATG001-VC
A.T.G. Industries Inc
760 INDUSTRIELLE STREET
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andrie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045819

PO Date: 2/10/20

Due Date: 2/26/20

Purchase Order

Revision:

Revision Date:

Issued By: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2020-02-14

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	206132	D5155-043	D5155 Rev B	Co-Pilot Collective Head Assembly (212/412) : Various STC's Anodize Black as per Dwg D5155 Rev. B	Firmed	-	2/26/20	2 pcs	0 pcs	2 pcs	\$6.54/pcs	\$13.08
2	206132	SWA6A-800A	SWA6A-800A Rev 4	Connector Bushing -Issue P/O to ATG: -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 WATER SEAL As Per Dwg SWA6A800 Rev. 4 - Certificate of Conformity is required	Firmed	-	2/26/20	30 pcs	0 pcs	30 pcs	\$4.09/pcs	\$122.70

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PURCHASE ORDER

POHB045819



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	206319	646.3812	646.3800 Rev A	Gusset Bracket : Various STC's Issue P/O to ATG: AS PER MPP- 172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A- 8625 TYPE 3 CLASS 2 AS PER MPP- 172 SECTION 4.3, PRIME CARDINAL 7760-4702 LOW VOC EPOXY PRIMER (LIGHT GRAY) Certification of Conformity is required	Firmed <i>X24</i>	-	2/26/20	24 pcs	0 pcs	24 pcs	\$6.89/pcs	\$165.36
FEB 24 2020												



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PURCHASE ORDER POHB045819



Items												
Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	206318	646.3810	646.3800 Rev A	Bracket : Various STC's Issue P/O to ATG: AS PER MPP- 172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A- 8625 TYPE 3 CLASS 2 AS PER MPP- 172 SECTION 4.3, PRIME CARDINAL 7760-4702 LOW VOC EPOXY PRIMER (LIGHT GRAY) Certification of Conformity is required	Firmed <i>X23</i>	-	2/26/20	24 pcs	0 pcs	24 pcs	\$7.34/pcs	\$176.16
FEB 24 2020												
5	206391	RBT18591- 7	RBT18591 Rev 2B	Vise Fixture (Outsource process- Anodize per QSI017 4.1.10.1) -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL-A- 8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed <i>X6</i>	-	2/26/20	6 pcs	0 pcs	6 pcs	\$9.79/pcs	\$58.74
FEB 18 2020												



Dart Aerospace Ltd.
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PURCHASE ORDER

POHB045819



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
6	204984	647.0210	647.0200 Rev N/C	Rail : Various STC's (Outsource process- Anodize per QSI017 4.1.10.1) Issue P/O to ATG : AS PER MPP- 172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A- 8625 TYPE 3 CLASS 2 AS PER MPP- 172 SECTION 4.2, PRIME AS PER IAW MIL- PRF-23377 TYPE 1 CLASS N	Firmed X16	-	2/26/20	16 pcs	0 pcs	16 pcs	\$11.29/pcs	\$180.64

FEB 24 2020



Dart Aerospace Ltd.
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PURCHASE ORDER POHB045819



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
7	204979	647.0111	647.0100 Rev B	Panel : Various STC's (Outsource process- Anodize per QSI017 4.1.10.1) Issue P/O to ATG: AS PER MPP- 172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A- 8625 TYPE 3 CLASS 2 AS PER MPP- 172 SECTION 4.2, PRIME AS PER IAW MIL- PRF-23377 TYPE 1 CLASS N Certification of Conformity is required	Firmed	-	2/26/20	16 pcs	0 pcs	16 pcs	\$40.04/pcs	\$640.64
8	206316	646.3715	646.3700 Rev A	Strut Doubler : Various STC's Issue P/O to ATG : Hard Anodize, Color Black and Prime as per Dwg 646.3700	Firmed X40	-	2/26/20	40 pcs	0 pcs	40 pcs	\$7.04/pcs	\$281.60

Grand Total: \$1,638.92

Sherrin



Dart Aerospace Ltd.
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PURCHASE ORDER POHB045819



Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit:
www.dartaerospace.com for further explanation.

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A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 919632

Date: 21-Feb-20

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
16 ea	Part: 647.0210 Rail Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1-2 mils) per drawing. Batch/Lot#: S 236137 Job: 26935 PO: POHB045819	Rev: N/C	DAS 82 9-89
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: FEB 21 2020 Certified Signature: <i>[Signature]</i> Receiver Signature: <i>[Signature]</i> A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.		Expiry Date: 05/29/2021 Line: 6	DAS 82 9-89

RECEIVED
FEB 21 2020
DART AEROSPACE LTD.

Made in Canada.